



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-041
Job Sheet 197138



Part No: D205-634-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/2/19

Job Tracking No:

Due Date: 7/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs		7/30/19	0.00	0.65	Skidtubes - Bend		MLC
120	Skidtubes - 2 - B4B	1 pcs		7/30/19	0.00	2.89	Skidtubes - 1 - B4B		DD
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
130	QC 5	1 pcs		7/30/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
140	Skidtubes - 3 - B4B	1 pcs		7/30/19	0.00	3.00	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		



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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
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Container No: S198247



Part: D205-634-041

Job No: 197138

Serial No/Batch: S198247

Revision: H

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 3, FAA STC SR005631

					Skidtubes - 3 - B4B	in Gile TF BE
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
150 QC 10	1 pcs	7/30/19	0.00 0.00		QC 10 - 10	JUL 2 2 2019
					QC 10 - 18 DAS	
					QC 10 - 24 24	
					QC 10 - 43 9-89	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
160 QC 5	1 pcs	7/30/19	0.00 0.00		QC 5 - 10	JUL 2 2 2019
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	7/30/19	0.00 1.31		Handfinish - 1 - 1 - B4B	JUL 2 2 2019 UL 14-7-2
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 -	

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				B4B	
				Handfinish - 1 - 22 - B4B	
180	Powdercoat - 1 White G(A)- B4B	1 pcs	7/30/19	0.00 0.34	Powdercoat - 1 - B4B
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
190	QC 3	1 pcs	7/30/19	0.00 0.00	QC 3 - 10
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
200	Handfinish - 4-1-Assembly- B4B	1 pcs	7/30/19	0.00 1.00	Handfinish - 4 - 1 - B4B
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
210	QC 5	1 pcs	7/30/19	0.00 0.00	QC 5 - 10
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	

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9-89

					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
220	Packaging 3-1 - Stock - B4B	1 pcs	7/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
225	DC - 1 - B4B	1 pcs	7/30/19	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	
230	QC 21 - FG	1 pcs	7/30/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	

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DAS
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9-89

AUG 02 2019

MB

Part Op 110 - Skidtubes - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe Descriptions: batch# in aft end of tube

120 - Skidtubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

130 - QC5- Inspect part completeness to step on W/O

140 - Skidtubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web.Deburr 5-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

150 - QC10- Inspect visual per QSI004- ground welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 5163437 Sikaflex expire date: 14-12-9 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 5163437 Sikaflex expire date: 5163437 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 14-12-9

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skiddtubes - Bend - 1	5192517
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skiddtubes - 3 - B4B	5177095
D4202-1	Spacer	20 pcs (20 ea)	140-Skiddtubes - 3 - B4B	5154389
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5159769
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5149158-1
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5192134
D2594-1	Plug	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5189025
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5173298
D2855	Cap	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5194521
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5185053
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5196277
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5185270
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5186896
NAS1149C0332R	Washer (AN960C10L)	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5158079
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5178379

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skiddtubes - Bend - 1	D2580-1	1	4	0
140-Skiddtubes - 3 - B4B	D2576-3	1	35	0
	D4202-1	20	601	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	1,404	0
	AN3-5A	2	154	0
	AN3C4A	50	1,357	0
	D2594-1	16	82	0
	D2594-3	16	227	0
	D2855	1	97	0
	D3564-11	1	7	0
	D3564-13	1	2	0
	D3564-5	1	3	0
	D3564-9	1	5	0
	NAS1149C0332R	50	4,682	0
	NAS1149D0332J	2	3,254	0

Part Specifications

Specifications could not be found.

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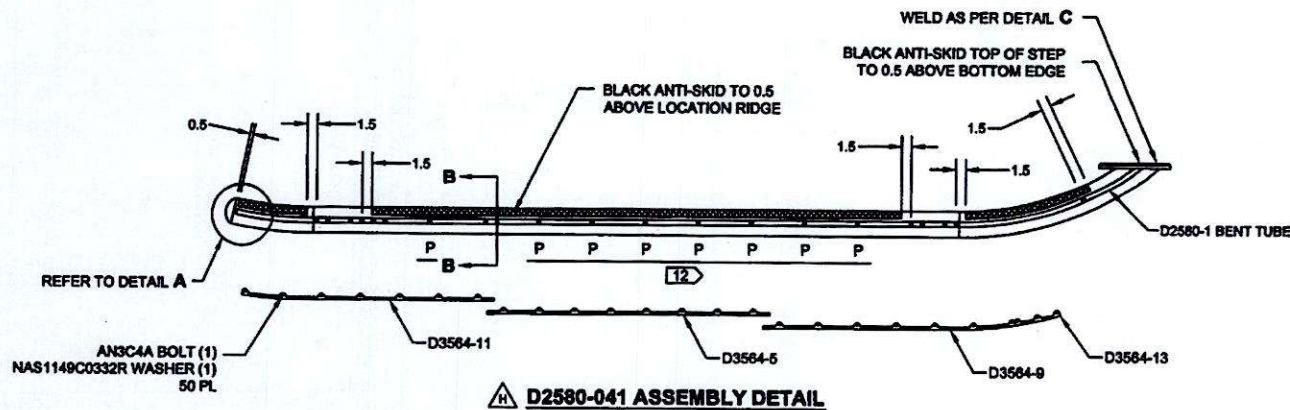
ITEM	QTY -041	QTY -046	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-046	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2600-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2576-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2584-1	PLUG
25	16	16	8	8	D2584-3	O-RING
26	1	1	1	1	D2586	205 WEB
27	1	1	1	1	D2585	AFT CAP
28	1	1			D3584-5	WEARSHOE
29	1	1			D3584-9	WEARSHOE
30	1	1			D3584-11	WEARSHOE
31	1	1			D3584-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4406-041	WEARPLATE ASSEMBLY
34			1		D4406-043	WEARPLATE ASSEMBLY
35				1	D5081-1	FWD WEARPLATE
36				1	D5081-3	AFT WEARPLATE
50	50	50			AL57-1032-130 or AK57-1032-130 or AK54-1032-130 or AEL5-1032-130	INSERT
51	50	50			AN3C4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-45A	BOLT
54	50	50			NAS1149C0332R	WASHER (AN880C10L)
55	2	2	2	2	NAS1149D0332J	WASHER (AN880JD10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

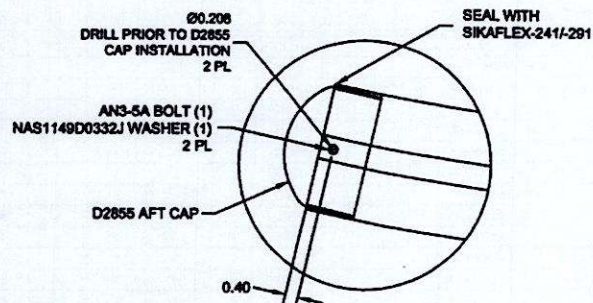
- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2586 WEB
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-046) GREEN SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: NONE
- WEIGHT: D2580-041 = 33.7 lbs
D2580-046 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- WELDING PER DART QSI 004.
- INSERT D2586 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE DT8217 & DT8637 ONLY FOR D2580-041/-046 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- INSERT D2584-1 PLUG C/W D2584-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-046 AND 8 PLACES FOR D2580-047/-049)
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2585 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

SHIP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 197138 M15
 190702 RELEASED
 2017 JUL 05
 ECR7-519

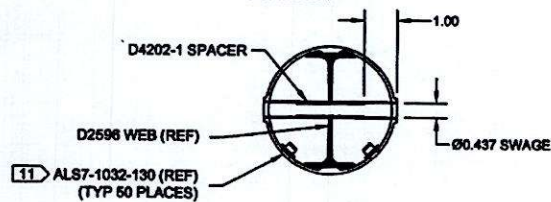
H	SHEET : PL DELETE D3586-1/-5/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048, -047 WEIGHT UPDATED PER DSI 9998	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-6); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8637 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO 88 WEARPLATES AND GASKETS, INCLUDE DEO 8124/8153	PH	07.04.06
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	06.06.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	17.06.09		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2580 TITLE 205 SKIDTUBE ASSEMBLY REV. H SHEET 1 OF 9 SCALE NTS COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			



DETAIL A
SCALE 5X

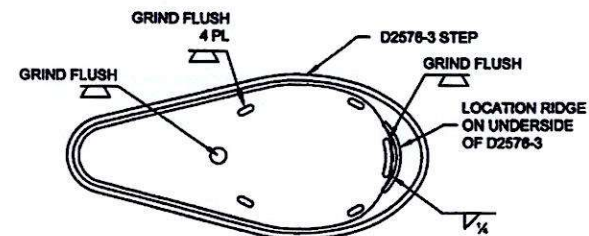


SECTION B-B
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

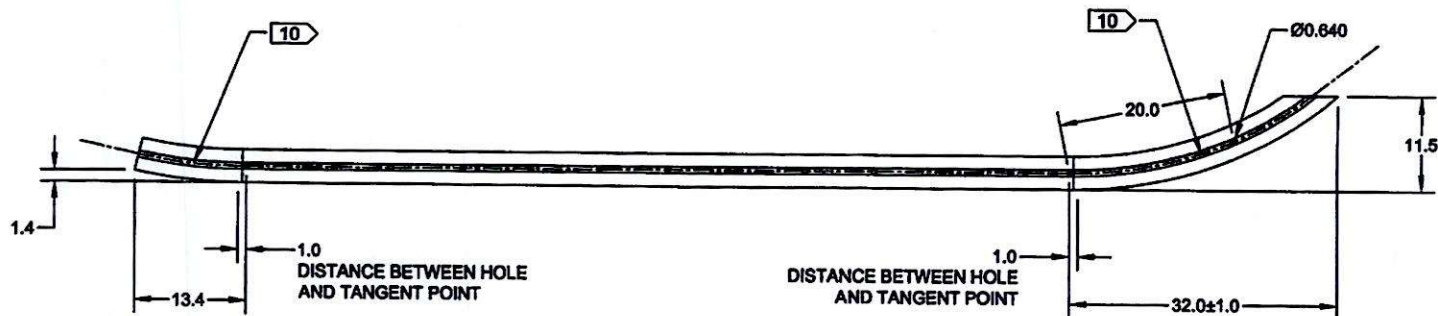
DETAIL C
SCALE 5X



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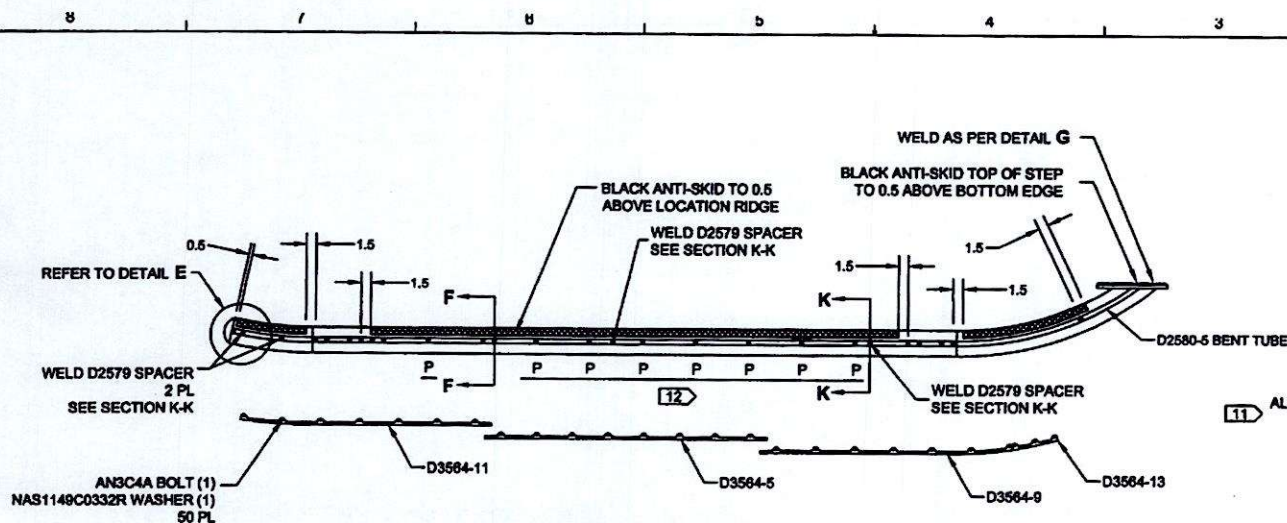
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 2 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	17.06.09	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

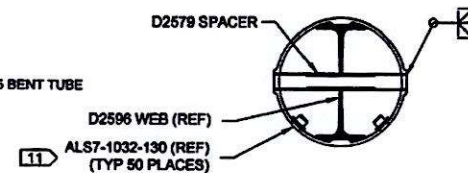
RELEASED
2017 JUL 05 4⁰

DESIGN	DS	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2580	REV. H SHEET 3 OF 9
MFG. APPR.	<i>[Signature]</i>	TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	17.06.09		



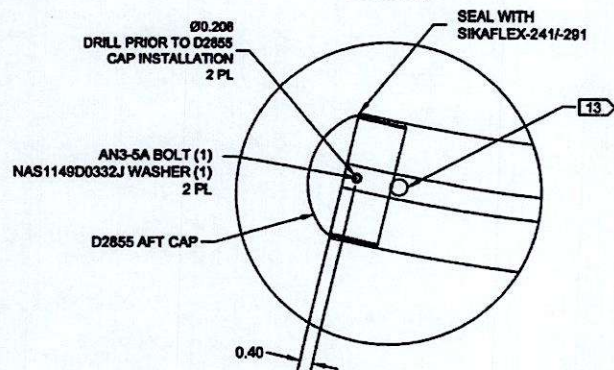
D2580-045 ASSEMBLY DETAIL

**SECTION K-K
SCALE 5X**

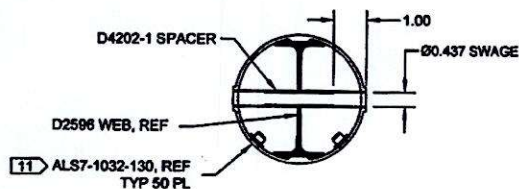


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT CBORE

**DETAIL E
SCALE 5X**

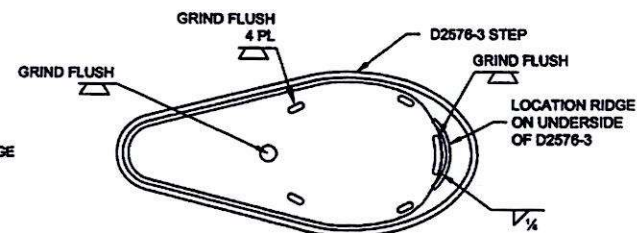


**SECTION F-F
SCALE 5X**



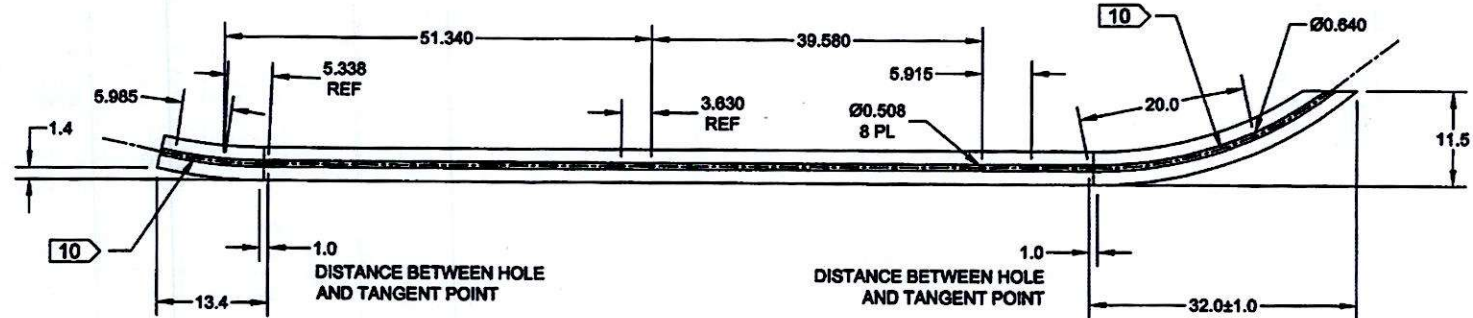
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

**DETAIL G
SCALE 5X**



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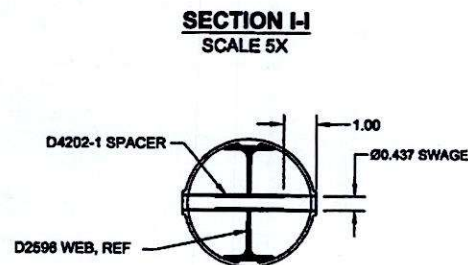
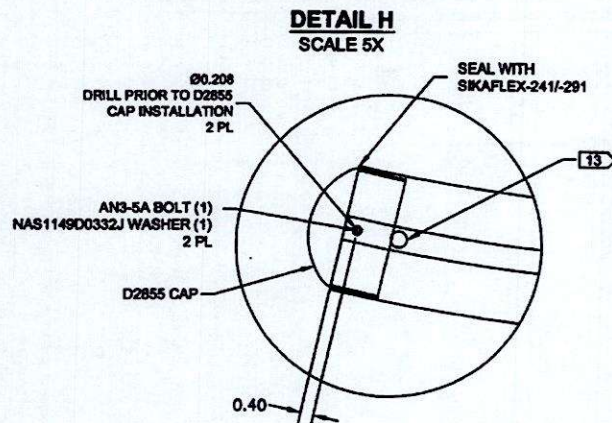
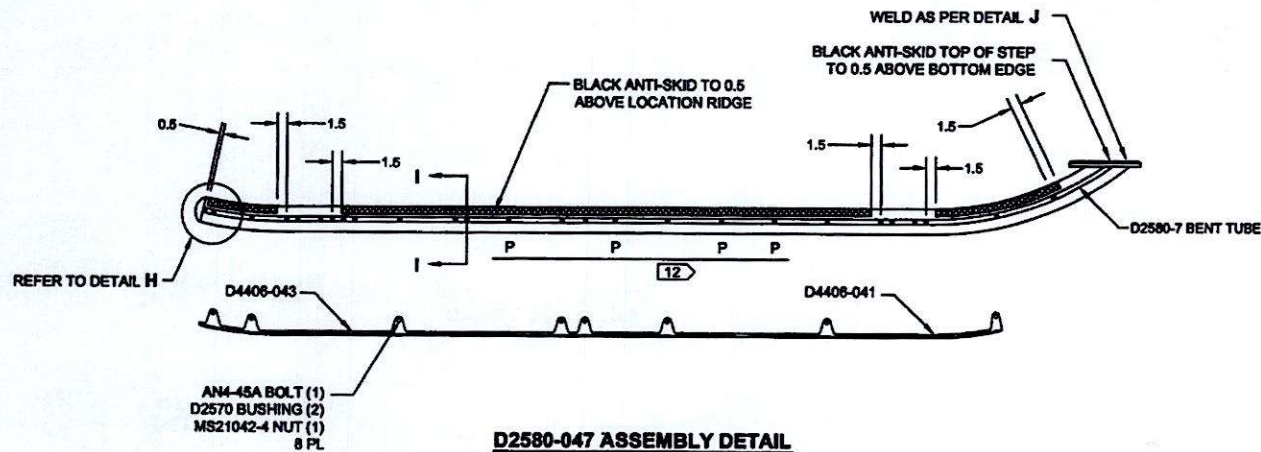


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

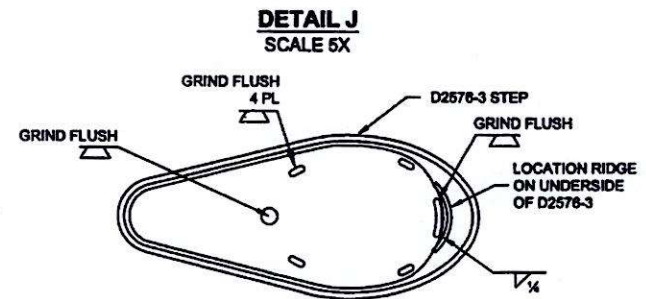
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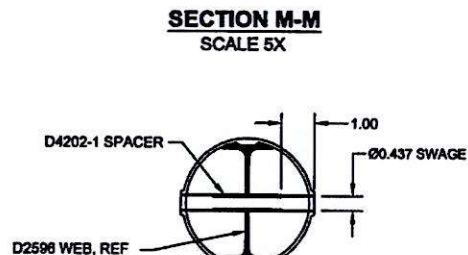
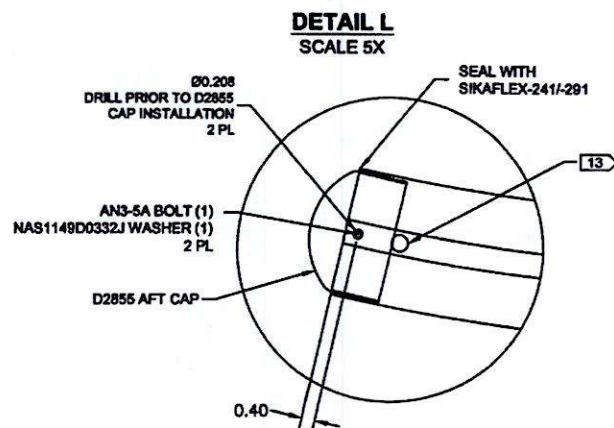
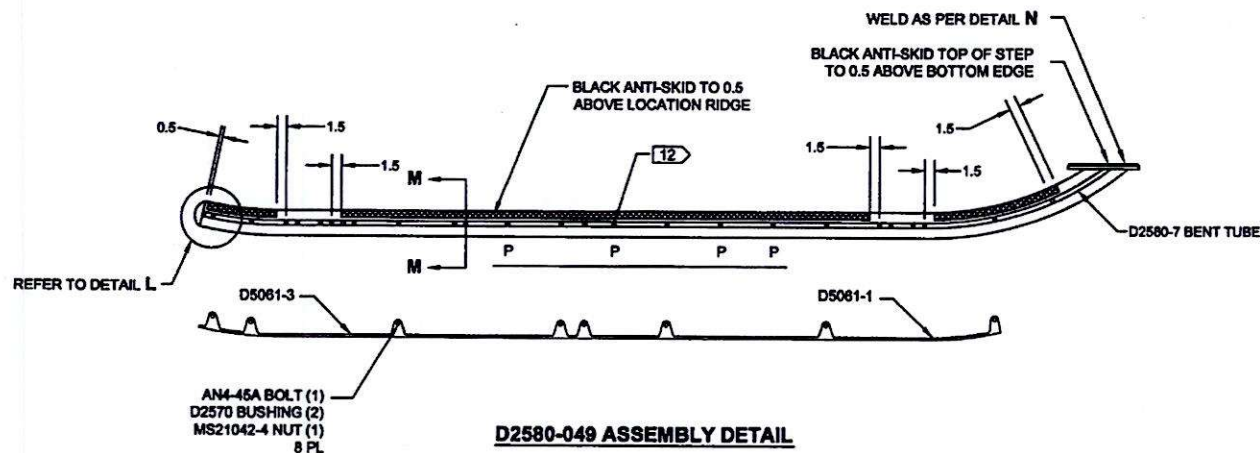
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



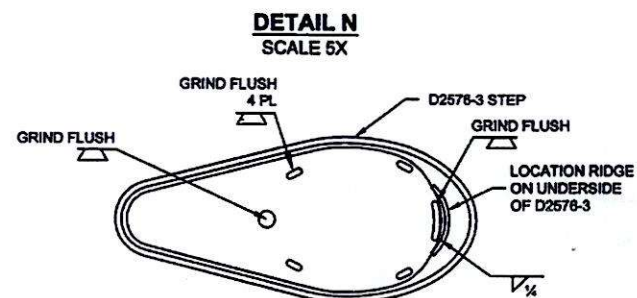
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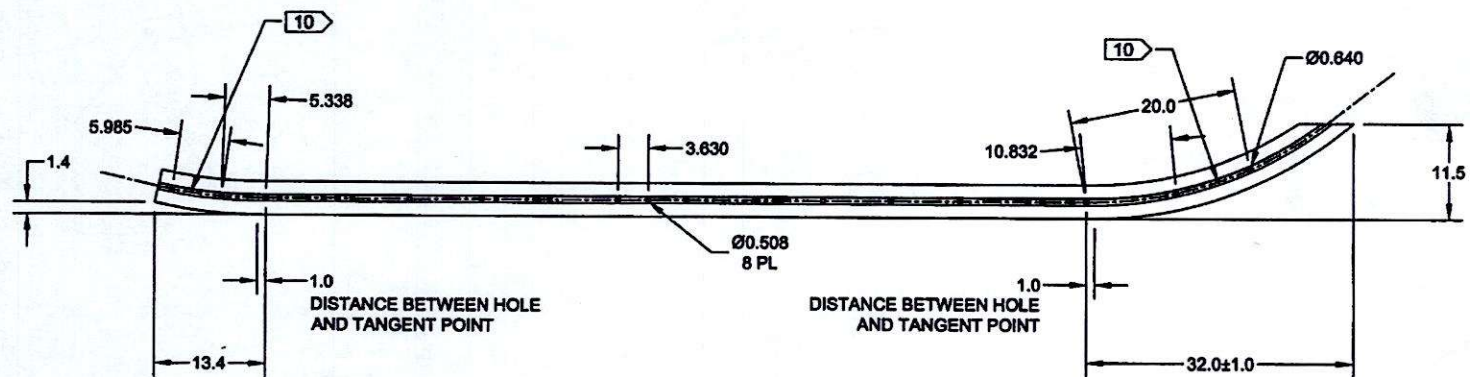
AFTER DRILLING AND BENDING ASSEMBLY
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2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



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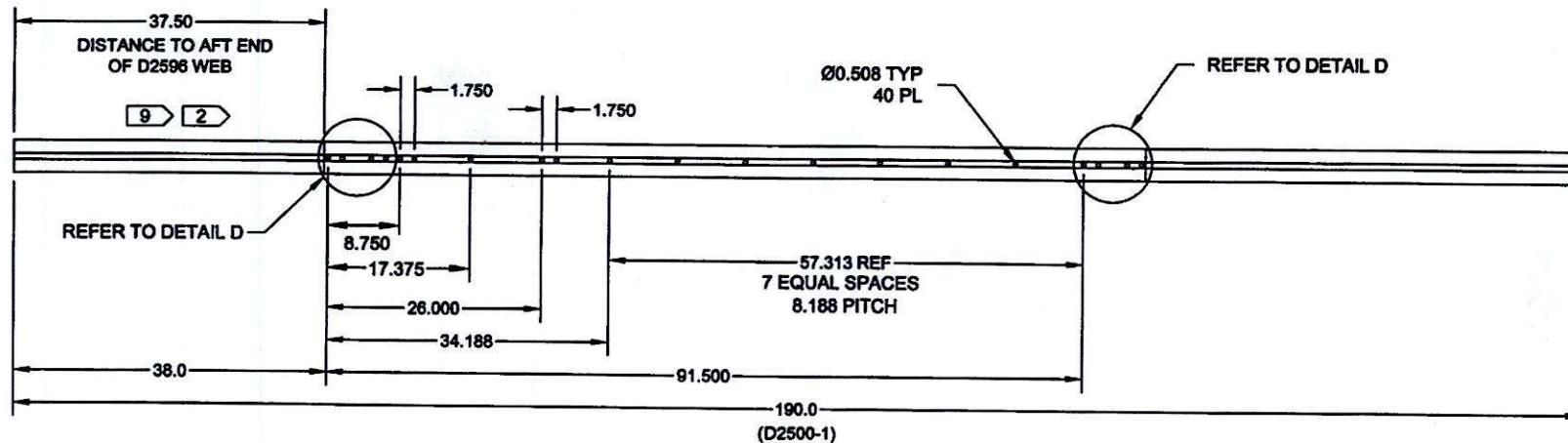
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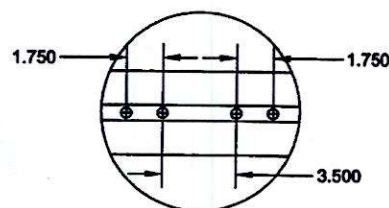
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D2580-101 TUBE



DETAIL D
SCALE 5X

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